Work Order ID 59318 Tuesday, June 01, 2010 8:37:25 AM							J	001	FYPL	NLE	Page 1	
Item ID: Revision ID:	D3955-23			Acce	pt					Setup Stai	t	
Item Name:	Template									Sto	р	
Start Date: Required Date Reference:	6/1/2010 e: 6/1/2010	Start Qty: 10.00 Req'd Qty: 10.00				Cust Item 1 Customer:	D:			·		11818 118 1181 1881
Approvals:	Process Pl	an: MF	Date: _10-6	-/ Too	oling:		ate:]	Run Star	t	
٠	,				C (Y/N):		ate:			Sto	p	
Sequence ID/ Work Center	ID	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr	<u> </u>									
D3955	A											
Waterjet FLOW CNC Wate		Memo 1-Cut as per	Dwg D3955		00		• • •	,	_B_(0-6-1		
6061 .	040	Dwg Rev: Prog Rev: 2-Deburr if n	<u>A</u>				,				(1))
		QC2- Inspect parts off ma	chine FAI/FAIB	0.4	00				152 /	0-6-1		
QC		Memo		0.	.00				N/2(0 0 (

Memo

Quality Control

W/O:			WC	ORK ORDER CHANG	GES			- 1.5		-
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				-				-		
·				i i						
Part No	:	PAR #:	Fault Cate	gory:	NCR	: Yes I	No DQ A	۸:	_ Date: _	
	R	esolution:	Disposition: Q						Date:	
NCR:			WORK ORDI	ER NON-CONFORM	IANCE	(NCR)			
DATE	STEP	Description of NC			Section B			ation	Approval	Approval QC Inspector
DATE	SIEP	Section A	Initial Action Desc Chief Eng Chief Eng			Sign & Date	Section C		Chief Eng	
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Work Order ID 59318

Tuesday, June 01, 2010 8:37:25 AM



Page 2

Item ID:

D3955-23

Accept

Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

Template

6/1/2010

QC:

Start Qty: 10.00 Req'd Oty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Date:

Date: _____

Tooling:

SPC (Y/N):

Date: Date:

Run

Start

Stop



Sequence ID/ **Work Center ID**

Required Date: 6/1/2010

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours**

Diololo1

Tool ID

Tool # Plan

Accept Code Qty

Reject Qty

Reject Number

Insp. Stamp

130

Packaging Packaging

Memo

0.00

0.00

140

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location: 05

0.00

Memo

0.00

CZ10/6/1

Quality Control

	-								
W/O:			WC	ORK ORDER CHANG	ES				<u> </u>
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						**			
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	\ :	Date:	
		esolution:							
NCR:		V	WORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC							l Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Approval Chief Eng	QC Inspector
***							:		
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Picklist Print

Tuesday, June 01, 2010 8:37:25 AM

Work Order ID: 59318

D3955-23 Parent Item:

Parent Item Name:

Template

Comments:

IPP RevA: New issue DD verified by:EC



Start Date: 6/1/2010

Required Date: 6/1/2010

Start Qty: 10.00

Required Qty: 10.00

B10-6-1

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No				sf	91.4000	0.3962	4.170526			

6061-T6 .040 Sheet

Location Loc Qty Loc Code MAT21 91.4 113004 91.4



W/O:			WC	RK ORDER CHANG	GES	and the second s	•			4-
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				:						
				·						
Part No	•	PAR #:	Fault Cate	gory:	NCR	: Yes	No DQ	A:	Date:	
	Re	solution:	Disposition	n:	QA: I	N/C Clo	sed:		Date:	
NCR:			WORK ORDE	R NON-CONFORM	IANCE	(NCR)			
DATE	STEP	Description of NC			VAI			erification Approve		l Approval
	0121	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sect	on C	Chief Eng	QC Inspector
						<u></u> -				
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DART AEROSPACE LTD	Work Order: 598/8					
Description: Template	Part Number: D3955-23					
Inspection Dwg: D3955 Rev: A	Page 1 of '					

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	1101	×			
Ø0.129	+0.005/-0.001	,131	4			
0.750	+/-0.010	,749	>			
1.000	+/-0.010	1,004	8			•••
1.250	+/-0.010	1.751	C			e e e
1.375	+/-0.010	1.371	Ø			-
2.563	+/-0.010	2,560	V 0			ve 10 1 2
0.800	+/-0.010	1800	8			900 BT. 4
1.500	+/-0.010	1.505	8			
2.250	+/-0.010	ゔ゚゚゚゚゚゙゚゙゚゚゙゙゚ゔ゚゚゙゙゙゙゙゚゙゙゙゙゚	9			
2.750	+/-0.010	2.744	y			
3.250	+/-0.010	3,252	7			
5.000	+/-0.010	5,001	8	*		
6.500	+/-0.010	6,503	X		·	
7.500	+/-0.010	7,502	8			
8.000	+/-0.010	7.995	×			
8.500	+/-0.010	8,500	7			-
9.375	+/-0.010	9.374	ð.			
9.625	+/-0.010	9.676	k			
10.600	+/-0.010	10.607	8			
11.13	+/-0.030	11,123	8			
0.040	+/-0.010	,039	y.			

Measured by:	TS .	Audited by:	Prototype Approval:	N/A
Date:	10-6-1	Date: 10(06(0)	Date:	N/A

Rev	Date	Change	Revise (// by	Approved
Α	09.07.29	New Issue	KJ %	WZ
<u> </u>			7	

W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE Part No. BAR # 5-44 Octoor 100 August 100 Augu					
DATE STEP PROCEDURE CHANGE				\$	
	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No.				Prod Wigi	
Part No.					
Part No.					
Part No.					
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Part No.					
Part No: PAR #: Fault Category: N	CR: Yes	No DQA	ı:	Date: _	
Resolution: Disposition: Q					
NCR: WORK ORDER NON-CONFORMANC	E (NCR)			
DATE STEP Description of NC Corrective Action Section B		Verifica	ation	Approval	Approval
Section A Initial Action Description Chief Eng Chief Eng			Section C		QC Inspector
		_			

€ SYM - 0.040 REF - 11.13 10.600 9.625 - 9.375 8.500 8.000 Ø0.098 7.500 19 PL 6.500 5.000 3.250 29° 2.750 2.250 - 1.500 Ø0.129 0.800 2 PL 0.0 R1.19 2.563

D3955-23 TEMPLATE

5

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM, 0.040 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-23" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.16 lbs

8

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Α

DESIGN DS, DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D3955 MFG. APPR. SHEET 5 OF 5 APPROVED TITLE SCALE SKIDTUBE TUNING KIT

COPYRIGHT 0 2009 BY DART AEROSPACE LTD

This coconduct is ensured, and completeling with a surround to the LOWES sociotion that it is a
out to be surrounded and with a control on Consulpoint to the John the following mining it. DE APPR NTS DATE 09.07.21

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Dart Aeros _l	pace Ltd
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W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
								:				
Part No:		PAR #:	Fault Category: NC			CR: Yes No DQA: Date:						
	R	esolution:	Disposition:							Date:		
NCR:	1 2		WORK OR	DER NON-CONF	ORMANCE	(NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section I				Verification		Approval	Approval		
	0121		Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector		
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4												
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